



Dart Aerospace Ltd.
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D206-642-341BL
Job Sheet 186094



Part No: D206-642-341BL

Job Qty: 1 ea

Part Name: Replacement Skidtube (Fits LH or RH)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2650 REV.F(DEO) IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verf: DD IPP Rev: L 12.11.22 now swage per ecn12-679 DD verf: JLM IPP Rev: M 14.04.25 ECN14-520 DD verf: JLM IPP REV: N 15.10.09 ADDED BL DD VERF: JLM IPP REV: O 16.01.22 PAR16-484 DD VERF: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/14/18	0.00	0.00	Start Up Skidtubes-1		SH
110	Skidtubes	1 pcs		12/14/18	0.00	1.58	Skidtubes-2		SH DAS 38
115	QC	1 pcs		12/14/18	0.00	0.00	QC5		38
116	QC	1 pcs		12/14/18	0.00	0.00	QC9		PD 12-11-18 9-89
120	HandFinish	1 pcs		12/14/18	0.00	1.17	HandFinish1		D.R. 18/11/22
125	QC	1 pcs		12/14/18	0.00	0.00	QC7-1		MAG
130	Skidtubes	1 pcs		12/14/18	0.00	1.58	Skidtubes-2		SH
140	QC	1 pcs		12/14/18	0.00	0.00	QC5		SH
150	Skidtubes	1 pcs		12/14/18	0.00	1.58	Skidtubes-2		SH DAS 38
180	QC	1 pcs		12/14/18	0.00	0.00	QC5		SH
190	HandFinish	1 pcs		12/14/18	0.00	1.17	HandFinish2		Rec'd D.R. 18/11/22
200	Outsource	1 pcs		12/14/18			ATE003-VC	DEC 0 4 2018	OT 18-12-03
205	QC	1 pcs		12/14/18	0.00	0.00	QC6		38
210	QC	1 pcs		12/14/18	0.00	0.00	QC14		SH 12-12-04
220	HandFinish	1 pcs		12/14/18	0.00	1.17	HandFinish4		SH 12-12-04 DAS
230	QC	1 pcs		12/14/18	0.00	0.00	QC3		DEC 0 5 2018 68
240	QC	1 pcs		12/14/18	0.00	0.00	QC5		DEC 0 5 2018 68
250	Packaging	1 pcs		12/14/18	0.00	0.00	Packaging3-1		DEC 21 2018 6 9-89
255	DC	1 pcs		12/14/18	0.00	0.00	DC		SH 11-11-18
260	QC21-FG	1 Ea		12/14/18	0.00	0.00	QC21		SH 11-11-18

Part Op 110 - 1-Deburr Fwd edge of tube 2-Scribe "Identify Batch Number" 3-Remove ridge on inside of Fwd edge of tube as per Descriptions: Dwg D2650 4-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R Aluminum Rod 5-Grind weld flush to cap on top surface only. 6-Cut aft end to length as per dwg D2650 7-Drill pilot holes using drill Jig DT8168A (A & B) and DT8025. 8-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297". 9-Open Aft Cap Hole using #6 Drill Bit 10-Open holes for Tow Ring to Ø 0.625" as per Dwg D2650, D2650-5 Drilling Detail 11-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650 12-Ream holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 13-Deburr.

130 - 1- Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting Start Date: _____ Time: _____ Finish Date: _____ Time: _____ A/R Sikaflex-291 M138943

Sikaflex expiry date: 11/03/06

150 - 1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA

W

Date

Work Order update only ☐

AGAINST DEPARTMENT/PROCESS

Cross tube	☐	Water Jet	☐	Engineering	☐
Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Composite	☐	Supplier	☐		

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Container No: S127741
Part: D206 - 642 - 341BL
Job No: 186094
Serial No/Batch: S127741
 Revision: _____
 Inspection: _____
 Exp Date: _____
 Instructions: TC STC SH98 - 4 Issue 2 of 4, STA SA00475SE 15/10/28, EASA STI

DART AEROSPACE
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 Hamilton, ON K8A 1K7
 CANADA
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

FAULT CATEGORY

Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Contamination	☐	Out of Sequence	☐	Part Moved	☐
Countersink	☐	Off-set	☐	Drawing	☐
Cut Too Short	☐	Mislabeled	☐	Finish	☐
Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐

OTHER :

200 - ISSUE PO 041916 Prime and Paint DELFLEET BLUE

220 - 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/R Sikaflex-291 N1138959 Sikaflex expiry date: 1-3 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive 3-Install MS27039-4-06 Screw 4-Inspect for foreign object per QSI 024 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R Sikaflex-291 N1138959 Sikaflex expiry date: 1-3 6- Install D2680-041 Nut Plate as per Dwg D2650 7-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: N1138962
250 - Identify and pack for shipping as per PPP D206-642-341 Location:FG083
255 - Photocopy bluefile and create labels per PPP D206-642-341 CHG005

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 Ea (1 ea)	90-Start up Operation	5108902
D2647	Cap	1 Ea (1 ea)	110-Skidtubes	5038805
D2654-5	Web	1 Ea (1 ea)	130-Skidtubes	5011680
D4720-1	Spacer	19 Ea (19 ea)	150-Skidtubes	5030687
ALS4-1032-130	Rivnut	54 Ea (54 ea)	220-HandFinish	5007271
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	220-HandFinish	F11137672
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	220-HandFinish	F11137886-0
D2646BL	Aft Cap	1 Ea (1 ea)	220-HandFinish	5013553
D2651-1BL	Plug	14 Ea (14 ea)	220-HandFinish	5013104
D2651-3	O-Ring	14 Ea (14 ea)	220-HandFinish	5027457
D2680-041	Nut Plate	1 Ea (1 ea)	220-HandFinish	N1135271
D3537-1	Wearpad	6 Ea (6 ea)	220-HandFinish	5097214
D3537-3	Wearpad	1 Ea (1 ea)	220-HandFinish	5013552
D4956-11	Wearplate Fwd	1 Ea (1 ea)	220-HandFinish	5036400
D4956-23	Wearplate Center Fwd	1 Ea (1 ea)	220-HandFinish	5089816
D4956-35	Wearplate Aft	1 Ea (1 ea)	220-HandFinish	5057867
MS27039-1-08	Screw	2 Ea (2 ea)	220-HandFinish	5043210
MS27039-4-06	Screw	1 Ea (1 ea)	220-HandFinish	F11137951-1
MS27039C1-08	Screw	54 Ea (54 ea)	220-HandFinish	5036482
NAS1149C0332R	Washer	54 Ea (54 ea)	220-HandFinish	5089467
NAS1149D0332J	Washer	2 Ea (2 ea)	220-HandFinish	5100407-1
NAS1149D0463J	Washer	1 Ea (1 ea)	220-HandFinish	5055952

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2620	1	17	0
110-Skidtubes	D2647	1	29	0
130-Skidtubes	D2654-5	1	5	0
150-Skidtubes	D4720-1	19	296	0
220-HandFinish	ALS4-1032-130	54	11,223	0
	CCR264SS3-3	2	306	0
	CR3212-4-03	2	182	0
	D2646BL	1	6	0
	D2651-1BL	14	135	0
	D2651-3	14	609	0
	D2680-041	1	37	0
	D3537-1	6	210	0
	D3537-3	1	42	0
	D4956-11	1	18	0
	D4956-23	1	27	0
	D4956-35	1	16	0
	MS27039-1-08	2	380	0
	MS27039-4-06	1	31	0
	MS27039C1-08	54	495	0
	NAS1149C0332R	54	3,265	0
	NAS1149D0332J	2	1,945	0
	NAS1149D0463J	1	3,231	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

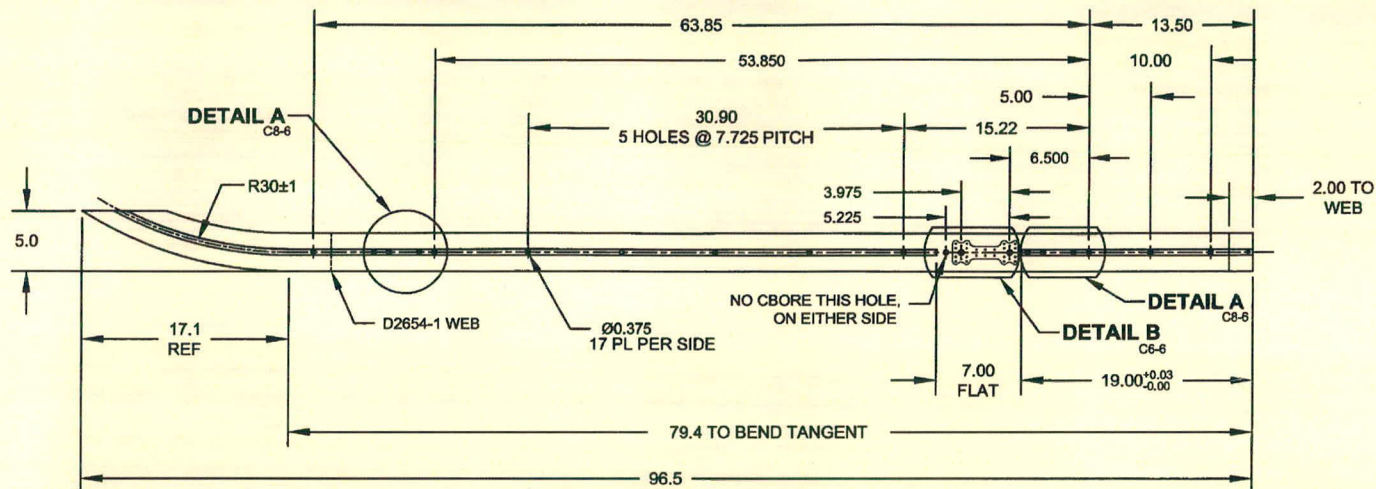
SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186094 MJS
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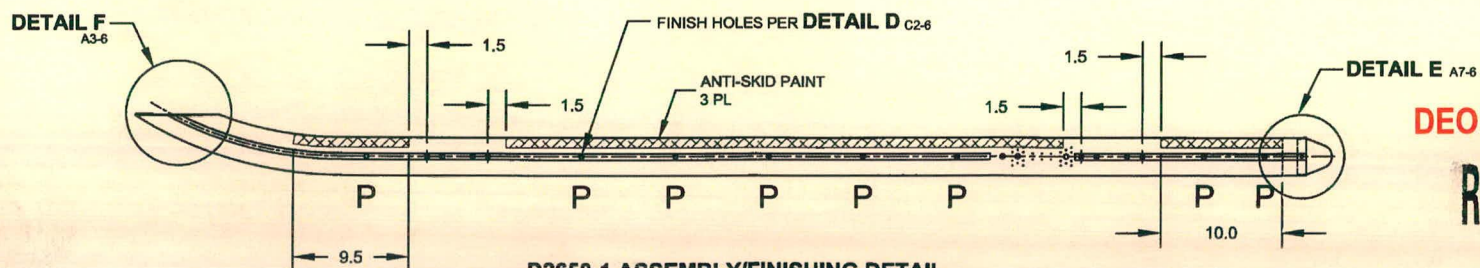
NOTES:

- MATERIAL: N/A
- FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: N/A
- WELD PER DART QSI 004
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



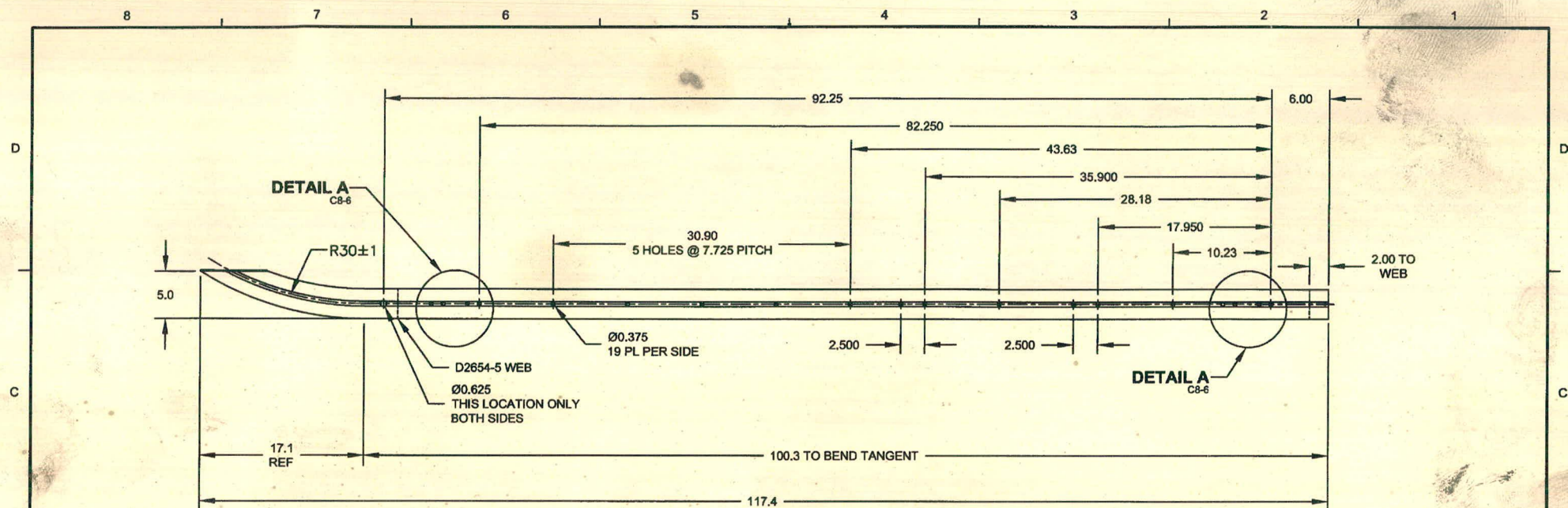
D2650-1 BENDING/DRILLING DETAIL



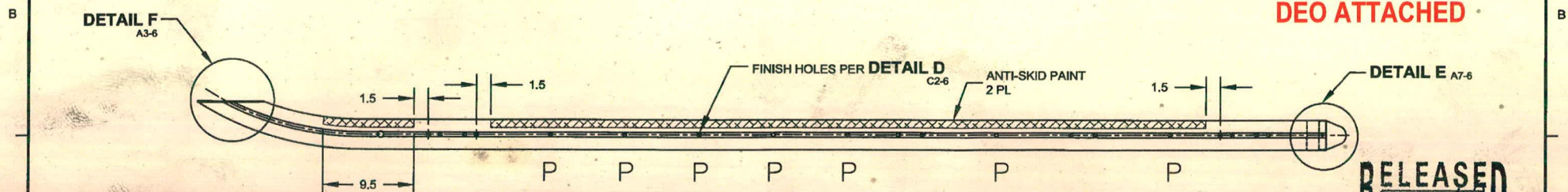
D2650-1 ASSEMBLY/FINISHING DETAIL

**DEO ATTACHED
RELEASED**
680922/117

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED A.P.	MFG. APPR. <i>DA</i>	APPROVED <i>#</i>	DE APPR. <i>#</i>			
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22			

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

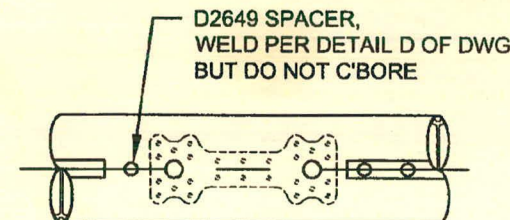
QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.

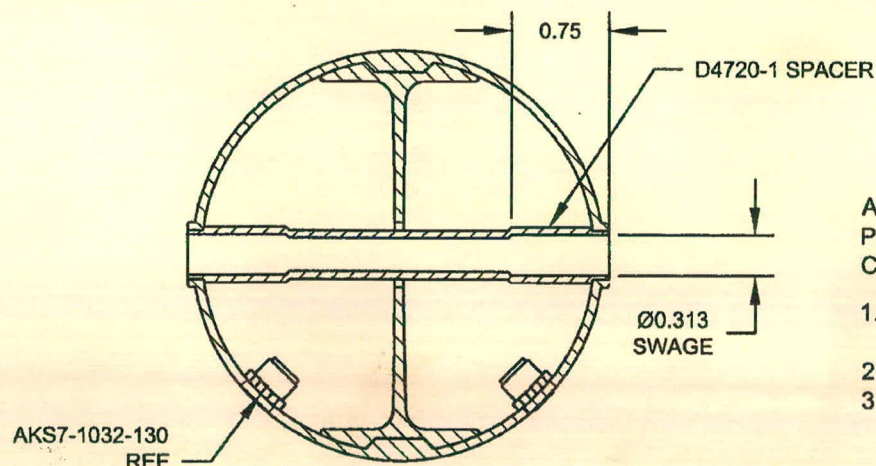
C'BORED HOLES ARE **NOW SWAGED** PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
MP



DETAIL G

FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041917**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041917
PO Date: 12/3/18
Due Date: 12/10/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186104	D2933-2BL	Saddle RH In, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	-	12/10/18	3 pcs	0 pcs	3 pcs	\$25.00/pcs	\$75.00
2	186096	D206-642-341BL	Replacement Skidtube (Fits LH or RH) : TC STC SH98-4 Issue 2, FAA STC SA00475SE 15/10/28, EASA STC EASA.IM.R.S.01320 Revision 1 07/09/10, JCAB JAPAN STC-102-TYO 00/09/25, ARGENTINA CTS- 0212.12(A) 02/12/26, BRAZIL 2009S08-21 09/09/02, BRAZIL 2009S08- 22 09/09/02 ISSUE PO Prime and Paint DELFLEET BLUE	Firmed	-	12/10/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
186098			DEC 04 2018	Firmed	-	12/10/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
186094			DEC 04 2018	Firmed	-	12/10/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
186095			DEC 04 2018	Firmed	-	12/10/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Sub Total:							4	0	4		\$900.00

Grand Total: \$975.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041917

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/3/18 10:33 AM dart.tsimiklis.chrisoula

